

Date:
User:

Wednesday, 21/01/2009 7:37:45 AM
Melanie Fauteux

Green

Dart Aerospace Ltd.

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	UPPER TUBE, BLADE POSITIONER
Job Number :	44974		
Estimate Number :	13442		
P.O. Number :		Part Number :	PB6743001285
This Issue :	21/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.37
First Issue :	1/1	Project Number :	N/A
Previous Run :	41374	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	27/01/2009
Written By :		Qty:	10
Checked & Approved By :	MF 09-01-21	Um:	Each
Comment :	Est Rev:A 08-06-27 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1500W125	6061T6 RD TUBE 1.50 X .125W
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Comment: Qty.: 5.2500 f(s)/Unit Total : 52.5000 f(s)

6061T6 TUBE 1.500X .125W

batch: M110680

MF 09/02/02

(10)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- deburr

MF 09/02/02

(10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/02/02

(H0)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- drill hole as per dwg

2- deburr

SP 09/02/02

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/02

(H0)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/01/2009 7:37:45 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER TUBE, BLADE POSITIONER

Job Number: 44974

Part Number: PB6743001285

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(10)

Comment: HAND FINISHING RESOURCE #1

FL 09/02/02

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

10:30

OVEN TEMPERATURE:

320°

FINISH TIME:

11:00

BR 1mp 09-02-05

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/05

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 446

AS 09/02/12 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/12

Job Completion



MF 09-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

B6743001 p.37

☒ **First Article** ☐ **Prototype**

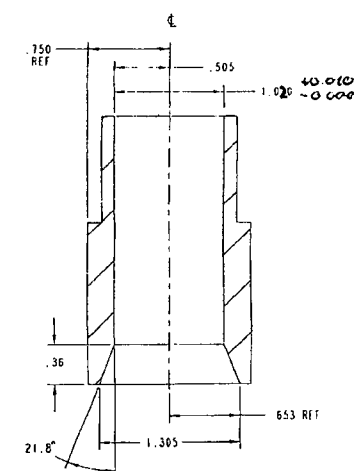
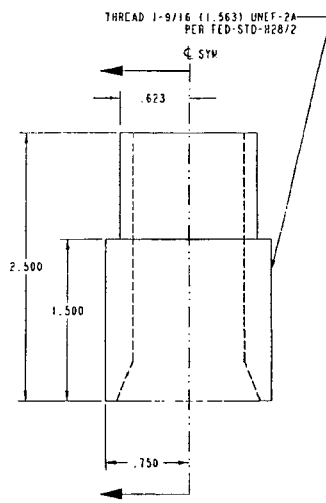
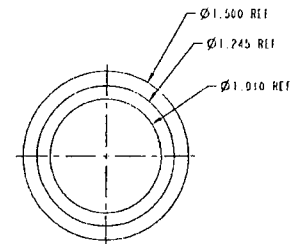
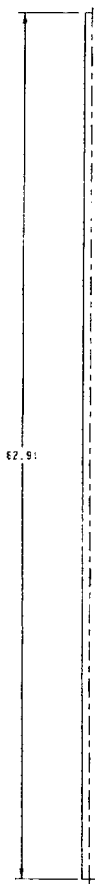
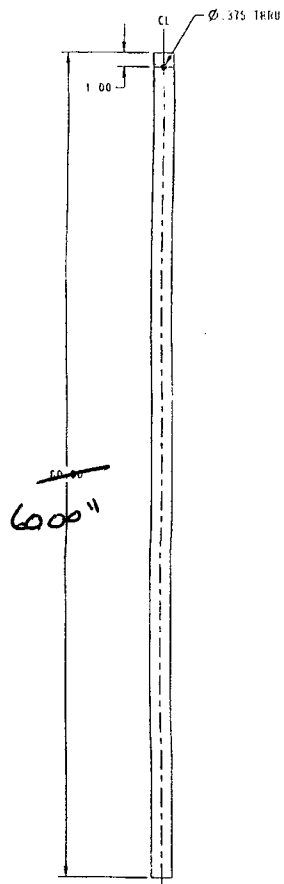
Measured by: <i>SE</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>07/02/02</i>	Date: <i>09/02/02</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	

43673

43673

RELEASED
43673



① -289 STATIONARY HANDLE ADJUSTMENT FITTING
JLM

MATL: 6061-T6, 00-A-200/8
SCALE 2.000

① -285 UPPER TUBE, BLADE POSITIONER
MATL: 1.50 OD X .125 WALL, 6061-T6, WW-T-700/6
SCALE 0.250

① -295 EXTENSION TUBE, BLADE POSITIONER
MATL: 1.00 O/D X .065 WALL, 6061-T6, WW-T-700/6
SCALE 0.250

PREMIER AVIATION, INC.
2002 Aviation Parkway, Grand Prairie, Texas 75052
D/OSUV8 B67 43001 87
SHEET 33 OF 45

ORIGINAL